

ABSTRACT

A method of highly efficiently producing pneumatic tires, wherein both bead portions (B) of a green tire (G) are supported by a pair of holders (24, 50) and opposite axial ends of a bladder (25) are tightly attached to the holders (24, 50), respectively. The holders (24, 50) are joined to each other and a fluid is supplied into the bladder (25), to preliminarily inflate the bladder (25) within the green tire (G). The green tire (G) is transferred into a vulcanizer, together with the holders (24, 50) and the preliminarily inflated bladder (25). A heat medium is supplied into the bladder (25), to vulcanize the green tire (G) and form a vulcanized tire (K). The preliminary inflation of the bladder (25) at a location outside of the vulcanizer eliminates or shortens the waiting time within the vulcanizer, thereby improving the overall work efficiency and productivity at a tire factory.